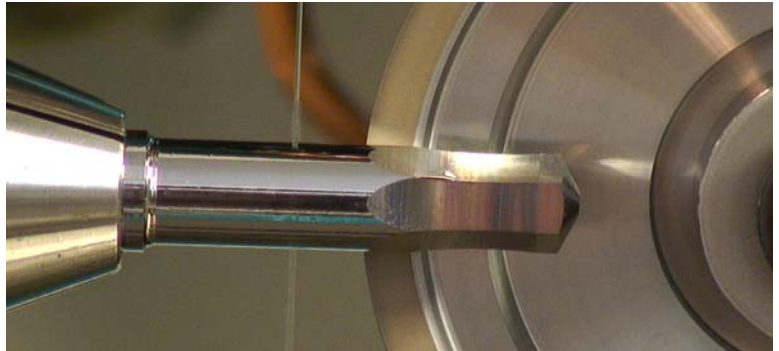















Punch Ø19,27 L80mm

A20-200

L'utensile è ricavato da un cilindretto di metallo duro. Viene prima affilato il gambo ribassato che serve per il bloccaggio sulla punzonatrice. Viene in seguito affilata la punta e il profilo esagonale a seconda della chiave richiesta. Tutto viene inoltre ripassato con mole grana D20 per ottenere la superfinitura e per permettere alla lappatura manuale con pasta diamantata di ottenere una superficie senza nessun segno.



1. Cycletime for Production

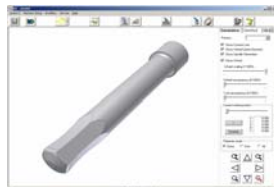
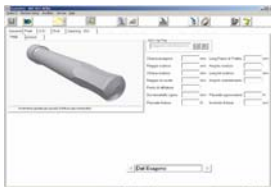
Tool specifications Diameter 19,27 mm, Material CARBIDE							
Operations							
Feed [mm/Min]	2000	1200	15	300	15	60	50
Power [kW]		1.2	0.4	0.8	0.4	0.8	0.4
Cutting feed [m/s]		20	40	22	40	22	40
Used wheels							
Grinding time [s]	34	360	1500	120	120	360	180
Total cycle time	44 Min 34						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

- 1: Ø125 1A1 D64
- 2: Ø125 1A1 D20
- 3: Ø100 11V9 D64
- 4: Ø100 11V9 D20
- 5: Ø100 (20°) 11V9 D64
- 6: Ø150 11V9 D20

3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **GEMINI**dmr AWL
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 5, DXQ
 Engineer: Diego Albiero, 31.08.2009

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